Work Orde July-31-12 9:57.		179		*88	179*						Page 1
Item ID: Revision ID:	D350-607-1	43	·	Accept	*N900	040	100)* s	etup Star	*N:	S1*
	Automatic Li	d Opener Installation	n						Stop	*N:	S2*
Start Date:	7/27/12	Start Qty: 1.0	00 *1*		Cust Item	ID:					
Required Date: Reference:	8/24/12	Req'd Qty: 1.0	*1*		Customer:				~.		
Approvals:	Process Pl	an: MJ	Date: 12/08/01	Tooling:	D	ate:		R	tun Star	1/1	R1*
	QC:		Date:	SPC (Y/N):	D	Date:			Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D350-607-1	Α										
1 \\n^ DC Document Control		Memo Photoc CHG0	copy bluefile &type labels per PP	0.00	loe hut B						
110		Pick Kit		0.00							50
110 Packaging Packaging		· Memo		0.00							13/09/11/
120		QC4- 100% Inspec	ct kits for completeness	0.00	Jalaly				\		
120 QC Quality Control		Memo	0	0.00 9 -53	/ (100 . (The state of the s			-

NCR:	Yes	/ No				WORK ORDER NON-	COL	NFORM	MANCE / UPI	DATE		_			٠ • <u>• •</u> •
											(QA Closed:	Date	<u>:</u> :	· · · · · · · · · · · · · · · · · · ·
Work Ord	er:					DISPOSITION				AGAINST I	DEP	ARTMENT/	PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	\prod	nitial	Act	ion		Sign &		$\overline{\top}$	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	iption		Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								•							
				•		F	AUL	T CATE	GORY						
Landi	ng G	iear				General							_	_	
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/l nance iled	Jnclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend		ı	Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde July-31-12 9:57		179		*881	79*						Page 2
Revision ID:	D350-607-1	43 d Opener Installation		Accept	*N900	0401	იი*	Setuj	Start Stop	ıu.	S1* S2*
Start Date: 7/27/12 Start Required Date: 8/24/12 Required Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		,		IV.	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		Run	Start Stop	"[]	R1* R2*
Sequence ID/ Work Center II 130 *130* Packaging)	Operation Description Memo		Set Up/ Run Hours 0.00	Tool ID		Plan Acc Code Qty			Reject Number	Insp. Stamp 12/09/1-
Packaging		Identify and Location: PPP rev: 1		PPP D350-607-143		-					
*140 *140* QC		QC21- Final Inspection -	Work Order Release	0.00					10	2/9	/18.J
Quality Control											

11209-18

NCR:	·												
									•		QA Closed:	Date	j:
Work Orde	er:					DISPOSITION			AG	AINST DE	PARTMENT	/PROCESS	
Part N	No.					Rework Scrap Use-as-is Work Order Update		f Therm	Machining Sma	istube all Fab ishing posite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								T CATE	SORY				
Landi	ng (Gear				General				·			
-	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	l	Torque W	aves in E	xtrusio	n	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print July-31-12 9:57:40 AM Work Order ID: 88179 Parent Item: D350-607-143 **Start Date: 7/27/12** Automatic Lid Opener Installation Start Qty: 1.00 Parent Item Name: IPP RevA: New issue DD verified by:EC IPP RevB: as per dwg revC DD **Comments:** 10.01.18 verified by:EC IPP Rev:C as per ecn10-545 DD 10.04.19 verified by:EC Component Item ID/ Replacement Qty on Qty per Kit Total Last Unit of Mfg/ Bin Route **Primary**

	Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Quy per 1110	Qty	Issued Iss	ued
5	D3953-7 Spring Spacer		Manufactured	No			110	Each	75.0000	1	1	" JB	sØ
					Location		Loc Oty	<u>L</u>	oc Code			V	
					ST075		25						
					857	89	25			8:	2789		
	<u>ز</u>				ST078		50				<u>.</u>		
					874	44	50				. ,		()
(D3953-31 Gas Spring Stud, Lid		Manufactured	No			110	Each	59.0000		ر 1	1 2B	- Sep) 4
					Location		Loc Oty	<u>L</u>	oc Code			V	
					GA		40						
					875	92	40			8	1592		
	1				ST075		19						
					857	88	19						\wedge
6	D3953-5 Gas Spring Stud, Base		Manufactured	No			110	Each	38.0000		1	JB	
					Location		Loc Qty	L	oc Code				
	λ				ST075		38						
					859	958	18			_₹:	5958		Λ.
					865	593	20					_	S
5	D3953-9 Gas Spring Washer		Manufactured	No			110	Each	63.0000	2	2	93	12/09/11
					Location		Loc Qty	Ţ	oc Code			V	, ,
					ST075		3						
					829	941	3						
					ST078		60						
	•				875	539	60			_8	7539		

Page 1

Status

Required Date: 8/24/12

Date

Required Qty: 1.00

Qty

NCR:	Yes	/ No				WORK ORDER NON-C	JOI	NFORI	MANCE / UPI	DATE	QA Closed:	Dat	te:	,
Work Ord	or.		· · · · · · · · · · · · · · · · · · ·			DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update] 1	Initial	Act	tion	Sign &		·	
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	١	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
						F	AUL	LT CATE	GORY					
Landi	ng (Gear				General		-			-			
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped				Bend BOM/Route Broken/Damaged Burrs		4	re ion Incomplete ions Incomplete/I	Unclear	Ovalized Over/Under Part Incorre Part Lost/M	ct		Pressure/Forced Temperature/Cure Weld · Wrong Stock Pulled
	Cuffs Contamination							Mainte	enance		Part Moved	·		
		Heat Trea			\vdash	Countersink		Mislabe		_	Positioned \		\Box	
	L_	Inspectio		Tube	<u> </u>	Cut Too Short		Misread	d	<u></u>	Power Loss/	Surge	Ш	Other
		Ripples ir				Drill Holes	\vdash	Offset						
1	Torque Waves in Extrusion Drawing							Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-31-12 9:57:41 AM

Work Order ID:	88179									
Parent Item:	D350-607-143					Start	Date: 7/27/12]	Required Date: 8	/24/12
Parent Item Name:	Automatic Lid Opener Installation					Star	t Qty: 1.00		Required Qty: 1	.00
03953-11 Gas Spring Spacer	Manufactured	No		110	Each	21.0000		1	JB	_S)?
U.			Location	Loc Oty		Loc Code				
			ST075	1				_		
			79338	1					•	
,			ST078	20				<u>.</u>		,
			. 87089	20			8708	29		
03953-15 Gas Spring Bracket	Manufactured	No		110	Each	15.0000		1	43	5
			Location	Loc Oty		Loc Code			•	
4			ST075	15						
			79337	15			433	37		Λ
D3953-17 Gas Spring Spacer	Manufactured	No		110	Each	56.0000		1	JB	ارک
			Location	Loc Qty		Loc Code			0	
			ST075	17						
			82937	1						
			85787	16						
			ST078	39				Ξ,		
1			87291	39			8729			6
D3969-1 Spring (Basket Lid)	Manufactured	No		110	Each	21.0000		1	JB_	5
			Location	Loc Oty		Loc Code			•	_
•			ST272	21		. ——				
A			73523	1						١.
			84424	20			8442	4		(L)
AN3CHA BOLT	Purchased	No		110	Each	32.0000	2	2	JB_	12/89/
			Location	Loc Qty		Loc Code			V	
			ST351	32						

											DQA:	Date	e: _	· · · · · · · · · · · · · · · · · · ·
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPDA	TE				•
											QA Closed:	Date	9:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS		
Work Ordi	-1.					Rework	1		Skid-tube C	Crosstube		Water Jet	٦	Engineering
Part I	No.					Scrap	1		<u> </u>	Small Fab	Pro	d. Eng. Coor.	f	Quality
						Use-as-is	1	i	noforming	Finishing	Rec/Stor	e/Packaging	┪	Other
NCR 1	۷o.					Work Order Update]		Large Fab C	omposite		Supplier		
Root			Ι		Descri	ption of work order update		Initial	Action		Sign &		_	
Cause		Date	Step	Qty	l	or Non-conformance	1	ief Eng	Descripti		Date	Verification	1	QC Inspector
Doc/Data													\dashv	
Equip/Tooling													1	
Operator			•											
Material												- -		
Setup														
Other														
Process													١	
Supplier													- [
Training														
Unapproved														
						F,	AUL	T CATE	GORY					
Landi	ng (Gear			_	General		-			-	_		
	L	Bending				Bend		Grain			Ovalized		\Box	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld
	_	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Uncl	lear	Part Lost/M	issing		Wrong Stock Pulled
,		Cuffs				Contamination		Mainte	nance		Part Moved			
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong _		
		Inspection	n Strip in	Tube		Cut Too Short	Misread	i		Power Loss/	Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-31-12 9:57:41 AM

Work Order ID:	88179											
Parent Item:	D350-607-143						-	Start !	Date: 7/27/12		Required Date: 8	3/24/12
Parent Item-Name:	Automatic Lid Ope	ner Installation						Start	Qty: 1.00		Required Qty: 1	1.00
- AN3C15A		Purchased	No			110	Each	29.0000	[2]	2	20	S
				Locatio	<u>n</u>	Loc Oty		Loc Code			0	v
)				ST352		29						
					119973	29			1199	13		Λ
AN310-4		Purchased	No			110	Each	79.0000	[2]	2		S
				Locatio	o <u>n</u>	Loc Qty		Loc Code				7
				ST344		79						
1					121349	2						- 11
					121827	77			121-8	27		
MS21043-3		Purchased	No			110	Each	843.0000	4	4	JB	
				Locatio	<u>on</u>	Loc Qty		Loc Code				-
				FG		72						
					103691	72						
				ST301		771						
					118077	2						
					118614	7						
					118686	30						
•					119758	20						
					121255 121708	20 692			151	708		Λ
100000000000000000000000000000000000000			Ma		121708	110		122.0000	141	200	i	(ا_
MS24665-2-12 COTTER PIN		Purchased	No			110	Each	122.0000		2	28	
ž				Location	<u>on</u>	Loc Qty		Loc Code				
1				ST309		122			11.50	100	•	
					118078	122			11-01	UB		~~~
NASJ149C0332R Washer		Purchased	No			110	Each	6,014.0000	(4	4	JB	12/09/
				<u>Location</u>	<u>on</u>	Loc Qty		Loc Code			V	. ,
				297		6014						
		`			122063	6014			122	063		

											DQA:	Dat	:e:	·
NCR: Y	es / No				WORK ORDER NON-C	100	NFOR	MANCE / UP	DATE					4
								80 - 0			QA Closed:	Dat	te:	
Work Orde	·r·				DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Work Orde	···				Rework	1		Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part N	lo.				Scrap		l .	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo				Work Order Update]		Large Fab	Composite			Supplier		
Root		<u> </u>	<u> </u>	Descri	I ption of work order update		I Initial	Ac	tion		Sign &	•		
Cause .	Date	Step	Qty	1	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	۱	QC Inspector
Doc/Data														-
Equip/Tooling		1												
Operator			i											
Material													- 1	
Setup .														
Other														
Process													1	
Supplier						l								
Training						İ								
Unapproved														
					F	AUL	T CATE	GORY						
Landir	ng Gear				General		-		,		-			
	Bending	;			Bend		Grain				Ovalized			Pressure/Forced
	Centre I	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		<u> </u>	Over/Under	tolerance	Ш	Temperature/Cure
	Cracks			.	Broken/Damaged		Inspect	ion Incomplete		<u></u>	Part Incorre	ct		Weld
	Crushed	I/Crimped			Burrs		Instruct	ions Incomplete,	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs			l	Part Moved									

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-31-12 9:57:41 AM

Work Order ID:

88179

Parent Item:

D350-607-143

Parent Item Name:

Automatic Lid Opener Installation

AS1149C0432R

Purchased

No

110

Each

5,958.0000

Start Date: 7/27/12

Start Qty: 1.00

Required Date: 8/24/12

Required Qty: 1.00

2 JB 12/09/11

<u>Location</u>	Loc Qty	Loc Code
296	3000	
1224	41 3000	
ST297	1070	
1172	91 70	
1191	1000	
ST298	1888	
1212	55 1888	121255

									DQA.	Date.	
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UP		QA Closed:	 Date:	•
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	lo		-		Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	1	1	I I	Descri	ption of work order update	Initial	Λ,	ction	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief En	l .	cription	Date	Verification	QC Inspector
Doc/Data		1						•			
Equip/Tooling											
Operator						1			,		
Material											
Setup											
Other											
Process											
Supplier						1					
Training											
Unapproved											
					F	AULT CAT	EGORY				
Landin	ng Gear				General						

Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Part Moved Contamination Heat Treat Mislabeled Positioned Wrong Countersink Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge **Drill Holes** Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

DART AEROSPACE LTD.

REFERENCE ONLY

D350-607-1 Page 22 of 22



6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	(Qty-	Qty -145	Part Number	Description
х			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	х		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		х	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1 1 -	D3953-3	GAS SPRING STUD (LID)
2			~D3953:5	GAS SPRING STUD (BASE)
2	7_1	1	-D3953-7	GAS SPRING SPACER
4 4	2	2	D3953-9	GAS SPRING WASHER
2	7 1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	-1		D3953-15 7	GAS SPRING BRACKET
~	* 1		_D3953-17	GAS SPRING SPACER
2 (. 1	1	D3969-1	GAS SPRING
4 /	2	2	AN3C11A	BOLT
1,2	72		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	12	2	AN310-4	CASTELLATED NUT
8 /	4-	4	MS21043-3	NUT
4	/ 2	2	_MS24665-212 /	COTTER PIN
8 (4.30	265(4 , 75)	NAS1149C0332R	WASHER (OR AN960C10L)
4	L_2	2	-NAS1149C0432R	_WASHER (OR AN960C416L)